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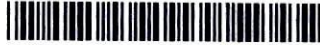
D3198-1
Job Sheet 166725



Part No: D3198-1

Job Qty: 8 ea

Part Name: Fitting



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/16/17

Job Tracking No:

Due Date: 10/31/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	8 Ea	10/30/17	0.00	0.00	Start up container	
100	Waterjet	8 pcs	10/30/17	0.00	0.52	Waterjet1	DAS
120	QC	8 pcs	10/30/17	0.00	0.00	QC8	38
130	Brake NC	8 pcs	10/30/17	0.03	0.50	Brake NC 1	DA9-89
140	QC	8 pcs	10/30/17	0.00	0.00	QC5	38
150	Powdercoat	8 pcs	10/31/17	0.00	0.15	Powdercoat3	BR 17-11-28
160	QC	8 pcs	10/31/17	0.00	0.00	QC3	9-80
170	Packaging	8 pcs	10/31/17	0.00	0.00	Packaging3	21
180	QC21-SA	8 Ea	10/31/17	0.00	0.00	QC21	NOV 30 2017

Part Op 100 - 1-Cut as per Dwg D3198

Descriptions: 130 - 1-Deburr if necessary 2-Form as per Dwg D3198

150 - START TIME: 4:55 ON 1:3000 FINISH: 5:25

IN 136370

ST021

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M304S11GA	1	72	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Fitting	0.266inches + 0.006 - 0.001	0.272 0.265		
2	Fitting	4.280inches ± 0.010	4.290 4.270		
3	Fitting	2.500inches ± 0.010	2.510 2.490		
4	Fitting	3.420inches ± 0.010	3.430 3.410		
5	Fitting	0.400inches ± 0.010	0.410 0.390		
6	Fitting	0.400inches ± 0.010	0.410 0.390		
7	Fitting	3.880inches ± 0.010	3.890 3.870		
8	Fitting	2.100inches ± 0.010	2.110 2.090		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPA- Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com	PROCESS Inter Jet ☐ Coord. ☐ gining ☐ lier ☐	Engineering ☐ Quality ☐ Other ☐
Part No. _____		Skid-tube ☐ Machining ☐ Thermofor ☐		
NCR No. _____				
Date: _____		Step #: _____		

Description Work Order Deviation

S003076

Fitting

D3198-1

Start up Operation
8
 Mfg Date: 10/27/17
 Job No: 166725

MRB (QSI042) Approval

Completed By

Hand / Supervisor
Approval VerificationCoordinator
Approval

Root Cause

Environment ☐	No Re-verification ☐	Pressure/Force ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Cont ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple, ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐			
Misidentified ☐	Past Due ☐	OTHER: ☐		

9

Fitting

3.020inches $\pm$ 0.010

3.030

3.010

Plex 10/16/17 10:32 AM dart.poulin.mario

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mis-labeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

